Work Orde Wednesday, Aug				*896	372*			AS				Page 1
Item ID: Revision ID: Item Name:	D212-725-1- Left Front Pan			Accept	*N900	<u>040</u>	100)*	Setup	Start Stop	*N:	S1*
Start Date: Required Date: Reference:	8/29/2012	Start Qty: 1.00 Req'd Qty: 1.00 _	*1* *1*		Cust Item l Customer:	ID:				•	" ! V.	S2*
Approvals:	Process Pla	n: MC	Date: \(\lambda \cdot 0 \cdot 3 \cdot \)	Tooling: SPC (Y/N):		ate:	- 			Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr						(1)				
D4255	A											
*100 *100* Waterjet FLOW CNC Waterj	/	Memo 1-Cut as per Dwg Rev: Prog Rev: 2-Deburr if n	Dwg D212-725-1-205	0.00							R12-	8-30
*110		QC2- Inspect parts off ma	achine FAI/FAIB	0.00							\$12·	15-P
QC		Memo		0.00				~				

Memo

Quality Control

												DQA:	Date:	
NCR: Y	es	/ No					WORK ORDER NON-C	O	VFORM	MANCE / UPD	ATE			
												QA Closed:	Date:	-
Work Orde	r:						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part N	o				·		Rework Scrap Use-as-is		ı	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o. -						Work Order Update			Large Fab	Composite	- Necyston	Supplier	other _
Root					Des	crip	otion of work order update		nitial	Acti	on	Sign &		
Cause		Date	Step	Qty		C	or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
oc/Data	╝													
quip/Tooling	_													
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etup	4													
ther	_	:												
rocess	4													
upplier	4									:				
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napproved				lj				<u></u>						
							······································	AUL	T CATE	GORY				
Landin F	_				ſ		General In		l.c:		_	٦		7_
}	_	Bending Centre No	t Cancan	stric to (7/5		Bend BOM/Route		Grain		}-	Ovalized	A	Pressure/Forced
-	\neg	Centre No Cracks	t Concen	ithe to t	ا درد		BOM/Route Broken/Damaged	\vdash	Hardwa		-	Over/Under	⊢	Temperature/Cure Weld
}		Cracks Crushed/C	rimpod		ŀ		Burrs	-	1	on Incomplete		Part Incorred	 	I
F	_	Crusneu/C Cuffs	impeu.		}		Contamination	\vdash	Mainte	ions Incomplete/U	- Inclear	Part Lost/Mi	122111B	Wrong Stock Pulled
.	-	Heat Treat	t		}		Countersink	\vdash	Mislabe		-	Positioned V	Vrong	
-		Inspection		Tube	}		Cut Too Short		Misread		<u> </u>	Power Loss/		Other
<u> </u>	_	Ripples in		. 450	}		Drill Holes		Offset	•	L.	Ti ower coss/	Jui 8c	Journal
<u> </u>	—	Torque Wa		xtrusior	, }		Drawing	<u> </u>	4	Calibration				
<u> </u>	_	Turning Se			.		Finish		1	Sequence				
	_	_			L			L		•				

Outside Dimensions

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Wave/Twist in Tube

Folio

Work Ord Wednesday, Aug				*89	672*					Page 2
Item ID: Revision ID:	D212-725-1-	205		Accept	*N90004	1100	* S	etup Sta	* *NS	31*
Item Name:	Left Front Pan	el						Sto	*NS	32*
Start Date:	8/29/2012	Start Qty: 1.00	*1*		Cust Item ID:					
Required Date:	8/31/2012	Req'd Qty: 1.00	*1*		Customer:					
Reference:										
Approvals:	Process Pla	n:	Date:	Tooling:	Date:		R	un Sta	"IZIF	₹1*
	QC:		Date:	_ SPC (Y/N):	Date:			Sto	*NF	R 2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID Tool	# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC8- Inspect parts - sec	ond check	0.00 Srs	Blan		1	•		-
120 QC Quality Control		Memo		8.G 00.0						
130		Chemical Conversion Co	oat per QSI005 4.1	0.00						0 . –
130 HandFinish Hand Finishing		Memo		0.00					7 10	<u>-8-31</u>
140 *1 4 0*		Spray Painting per QSI0	05 4.2	0.00			AS	10		,
SprayPaint		Memo		0.00			- M	19	<u>-8-3</u>	<u>!</u>

PAINT FLAT BLACK AS PER DWG

Spray Painting

											D	QA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORI	MANCE / UP	DATE				
											QA Clos	sed:	Date:	
Work Ord	er:					DISPOSITION	٠			AGAINST D	EPARTMI	ENT	/PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Rec		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign	&	,	
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	е	Verification	QC Inspector
Doc/Data	Ш													
Equip/Tooling	Ш													
Operator	Ш													
Material	Ц													
Setup	Ш													
Other	Ш													
Process	Ш						1							
Supplier	Ы						1							:
Training	Ш													
Unapproved			<u> </u>				<u> </u>				<u>.</u>			
		· · · · · ·					AUL	T CATE	GORY					
Landi					_	General								-
	-	Bending			_	Bend	\perp	Grain		L	Ovalized	d		Pressure/Forced
	Ш	Centre No	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa	re	L	Over/U	nder	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Inc	orre	ct	Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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Work Orde Wednesday, Aug				*896	372*			100				Page 3
Revision ID:	D212-725-1			Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1* S2*
	8/29/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					I VI .	
Approvals:		an:				ate:			Run	Start Stop	*NI *N!	R1* R2*
Sequence ID/ Work Center II 150 *150* QC	D	Operation Description QC3- Inspect Part Finish		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt	•	Reject Number	Insp. Stamp
Quality Control		Memo Identify as per dwg & St		0.00								
160 Packaging Packaging		Мето	SINT	0.00						142	(9/4	<u>() </u>
170 *170* QC QC Quality Control		QC21- Final Inspection	- Work Order Release	0.00						12	9/1	1 34

mr 12-09-04

				DQA:	Date:	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE	_	_	

									QA Closed:	Date	•
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	o				Rework Scrap Use-as-is Work Order Update	- 1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	i .	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved			QCY			ciner zing				Vermedion	ge inspector
onapproved 1				L <u>. </u>	F	AULT CATE	GORY			1	
Landin	g Gear				General					<u> </u>	
	Bending Centre No Cracks Crushed/O			o/s	Bend BOM/Route Broken/Damaged Burrs Contamination	Instruct	are ion Incomplete tions Incomplete/I	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Heat Trea	ıt			Countersink	Mislabe	eled		Positioned V	Vrong	
ļ-	Inspection	n Strip in	Tube		Cut Too Short	Misread		•	Power Loss/		Other
	Ripples in				Drill Holes	Offset		L	_	- L	
	Torque W	aves in E	xtrusio	,	Drawing	Out of	Calibration				
	Turning S	equence			Finish	Out of !	Sequence				
	Wave/Tw	ist in Tub	e		Folio	Outside	Dimensions				

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Picklist Print

Wednesday, August 29, 2012 4:38:58 PM

Work Order ID:

89672

Parent Item:

D212-725-1-205

Parent Item Name:

Left Front Panel

Start Date: 8/29/2012

Required Date: 8/31/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: new issue DD 10.02.10 verified by:JLM 10.04.09 verified by:ILM

IPP Rev:B as per ECN10-532 DD

	10.04.09 Verified b	y:JLM											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	71.0881	2.319	2.4410526	172 (2-8-3	.O
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT021 121	473	71.0880789 18.3380789			17.1	123 (T	2	5
					:521	52.75			+=1	-(1	بح		•

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

								·		QA Closed:	Date:	
Work Orde					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap Use-as-is		ľ	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	-1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o				Work Order Update			Large Fab	Composite	, Nec/3101	Supplier	
Root				Descri	ption of work order update	Init	tial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator												
Material											·	·
Setup												,
Other		1							•		·	
Process		ļ										
Supplier												
Training		1										
Unapproved		<u>. </u>	<u> </u>			0111 T	CATE	CODY		<u> </u>		
	- C					AULT	CATE	JORY				
Landin	g Gear Bending			<u> </u>	General Bend		rain		_	Ovalized		Pressure/Forced
-	Centre No	nt Conco	ntric to	0/5	BOM/Route	 	ram ardwa	ro	· 	Over/Under	tolorance	Temperature/Cure
-	Cracks	ot conce	intric to	^{0/3} -	Broken/Damaged			on Incomplete		Part Incorre	-	Weld
ŀ	Crushed/	Crimped		<u> </u>	Burrs	_		ions Incomplete/	Unclear	Part Lost/M		Wrong Stock Pulled .
f	Cuffs	c.mpcu.	•		Contamination	\vdash		nance	-	Part Moved		
F	Heat Trea	at			Countersink	\vdash	islabe			Positioned V	Vrong	
<u> </u>	Inspectio		Tube		Cut Too Short	\vdash	lisread		 	Power Loss/		Other
ļ	Ripples in	-			Drill Holes	-	ffset		<u> </u>	<u> </u>	· _	
	Torque W		xtrusio	n	Drawing			Calibration				
	Turning S				Finish	-		Sequence		· · · · · · · · · · · · · · · · · · ·		
F	Wave/Tw				Folio	По	utside	Dimensions				

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DART AEROSPACE LT	D	Work Order:	87670
Description: Left Front Pane	el	Part Number:	D212-725-1-205
Inspection Dwg: D4255	Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.965	+0.012/-0.001	1.968	K		U BUZ	
Ø2.265	+0.012/-0.001	2.065	5	•	V	
Ø2.828	+0.012/-0.001	B 68.6	K		V	
Ø3.165	+0.012/-0.001	3,164	١		1/	
21.69	+/-0.030	2009	4		T BOI	
15.40	+/-0.030	15,40	7		7	
0.125	+/-0.010	(5)	3		V	

Measured by:	Audi	ted by: Smb	DAG	Preliminary Approval:	
Date: 12 - 6 -	- 30	Date: 12-8-3) 9-83 17	OS/80 Date:	

Rev	Date	Change	Revised by	∧ Approved
Α	12.02.02	New Issue	KJ (
				71

NCR: Y	es/	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE				
											QA Closed:	Date:	
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS					<u>†</u>
Part No						Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstu Machining Small F Thermoforming Finishi Large Fab Compos			I Fab		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		_				ption of work order update	1	Initial	Action		Sign &	_	
Cause	_	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					<u>-</u>								
						F	AUL	T CATE	GORY				
Landir	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend				o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		4	on Incomplete ions Incomplete/Unclear nance led		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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D R52.0 -D 16.97 16.70 Ø1.965 R0.50 15.40 R50.0 -R0.19 13.85 13.15 13.00 12.85 12.15 R1.00 - 10.13 С 9.14 С 8.33 Ø3.165 2 PL Ø2.265 4 PL 6.750 6.39 4.00 Ø2.828 2 PL R0.14 R0.25 1.88 2 PL 0.00 R0.75 В 21.69 19.76 3 PL 6.50 2.50 0.00 NOTES: 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 D212-725-1-205 LEFT FRONT PANEL (GENERATION 2 PANEL) REF DART SPEC. M6061T6S.125 OR 2024-T3 ALUMINUM SHEET OR 2024-13 ALUMINUM SHEET
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S. 125
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PAINT FLAT BLACK USING BASF GLASURIT 22 LINE CODE SFA39.50
PER DART QSI 005 4.2 A NEW ISSUE 11.02.24 DESCRIPTION REV. BY DATE DESIGN RF DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED DRAWING NO. CHECKED 4) UNITS: INCHES UNLESS OTHERWISE NOTED REV. A D4255 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX MFG. APPR. SHEET 1 OF 3 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 7) WEIGHT: 2.30 lbs APPROVED TITLE SCALE **INSTRUMENT PANEL** DE APPR. NTS COPYRIGHT © 2011 BY DART AEROSPACE LTD DATE 11.02.24 8 2

									DQA:	Date:			
NCR: Yes	/ No				WORK ORDER NON-C	CONFORM	MANCE / UF		QA Closed:	Date:			
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No					Rework Scrap Use-as-is Work Order Update]	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other		
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling													
Operator													
Material	•												
Setup													
Other								•					
Process													
Supplier													
Training													
Unapproved			1								į		

FAULT CATEGORY

Landing Gear General								_
		Bending		Bend		Grain	Ovalized	Pressure/Forced
		Centre Not Concentric to O/S		BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
		Cracks		Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
		Crushed/Crimped.		Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
		Cuffs		Contamination		Maintenance	Part Moved	
		Heat Treat		Countersink		Mislabeled	Positioned Wrong	 _
		Inspection Strip in Tube		Cut Too Short		Misread	Power Loss/Surge	Other
		Ripples in Bend		Drill Holes		Offset		
		Torque Waves in Extrusion		Drawing	Г	Out of Calibration		
		Turning Sequence		Finish		Out of Sequence		
		Wave/Twist in Tube		Folio	П	Outside Dimensions		